

# Work Order ID 63321

Wednesday, October 27, 2010 3:01:24 PM



Page 1

Item ID: D3681-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Spacer					
Start Date: 10/27/2010	Start Qty: 30.00		Cust Item ID:		
Required Date: 11/11/2010	Req'd Qty: 30.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 10/27	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3681	Rev A								

100	Hardinge CNC LATHE SMALL	0.00							
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA711 & DWG D3681								
	FOLIO REV:								
	DWG REV:								
	2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

10.11.9 30

10.11.9 30

10/11/09 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3681-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 10/27/2010

Start Qty: 30.00



Cust Item ID:

Required Date: 11/11/2010

Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

125

0.00



Skidtubes

Memo

0.00

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

30 0 BE 10/12/07

130

0.00



Packaging

Identify as per dwg & Stock Location

LG

Memo

0.00

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

30 0 BE 10/12/07

140

0.00



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

10/12/08

BS 1012-8  
(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

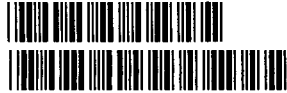
Wednesday, October 27, 2010 3:01:28 PM

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Work Order ID: 63321

Parent Item: D3681-1

Parent Item Name: Spacer



Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A new issue 07-10-30 DD verified by:EC  
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add  
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05  
8

Purchased

No

100

f

96.4337

0.34

10.73684



ALUM TUBE .3125 x .058w



10.11.9

Location

Loc Qty

Loc Code

MAT

19.43368421

14559

19.4336842

MAT013

77

115894

77

10.25

W/O:		WORK ORDER CHANGES					
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**Dart Aerospace Ltd**

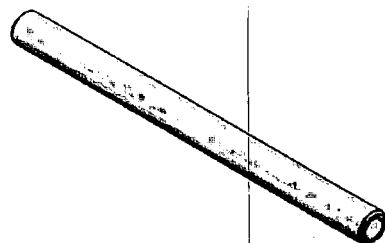
W/O:		WORK ORDER CHANGES					
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

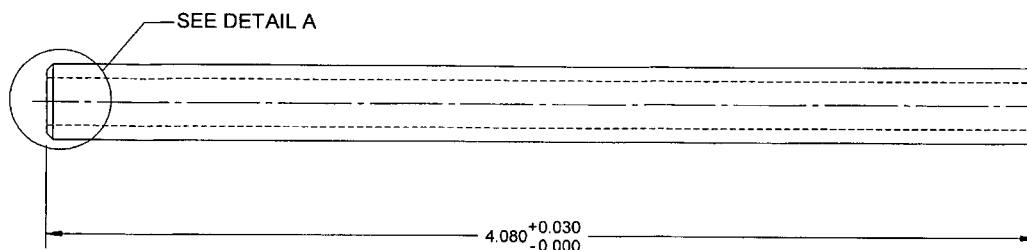
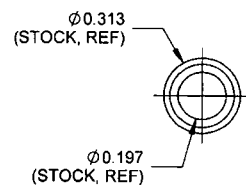
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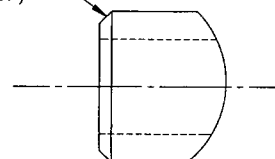




**D3681-1 SPACER**



0.025 X 45°  
CHAMFER  
(TYP)



**DETAIL A**  
(SCALE 4 : 1)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43321

*BP 10-10-27*

**RELEASED**  
07-11-08

**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082  
OR QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA			
DRAWN	SC				
CHECKED	MS	DRAWING NO.		REV. A	
MFG. APPR.	EP	D3681			SHEET 1 OF 1
APPROVED	W	TITLE		SCALE	
DE APPR.	#	SPACER			2:1
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

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